








# Work Order ID 71871

Wednesday, July 13, 2011 11:02:55 AM



Page 1


Item ID:	D1049	Accept		Setup	Start	
Revision ID:						
Item Name:	Saddle				Stop	
Start Date:	7/14/2011	Start Qty:	24.00		Cust Item ID:	
Required Date:	7/28/2011	Req'd Qty:	24.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CMF</u>	Date:	<u>11-07-13</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D1049	Rev A

100		<del>SHEAR</del>	0.00	FK 11-07-25 24 
Shear		Memo	0.00	
Shear		Cut Blanks: 2.000" long		

110		HAAS CNC VERTICAL MACHINING #1	0.00	Issue P.O. 14572 Don's Precision machine per drawing D1049 Rev.A
HAAS 1		Memo	0.00	
HAAS CNC vertical machine #1		1-Machine as per folio FA217 & Dwg D1049 2-Deburr		

*Purchasing*

120		QC2- Inspect parts off machine FAI/FAIB	0.00	CL 11/08/25 24
QC		Memo	0.00	
Quality Control		Review & inspect for transit damage Ensure C of C attached		

*PKG*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71871

Wednesday, July 13, 2011 11:02:55 AM



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Item ID: D1049

Accept



Setup Start



Revision ID:

Item Name: Saddle

Stop



Start Date: 7/14/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC

Quality Control

QC Inspect parts - second check

0.00

Memo

0.00

5 w/look

count  
424

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

24X Ø M-14/08/26

150



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Memo

START TIME:  
OVEN TEMPERATURE:  
FINISH TIME:

0.00

9:45  
320 OF  
10:15

24X Ø M-14/08/26

M11.5128

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 71871**

Wednesday, July 13, 2011 11:02:55 AM

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Item ID: D1049

Accept

Revision ID:

Item Name: Saddle

Start Date: 7/14/2011 Start Qty: 24.00

Required Date: 7/28/2011 Req'd Qty: 24.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

11/8/09

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location: ST

Sylvie

0.00

Memo

0.00

sf

11-08-09

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/8/09

11/8/09

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, July 13, 2011 11:02:53 AM

Page 1

Work Order ID: 71871

Parent Item: D1049

Parent Item Name: Saddle



Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP RevC02.04.10Re-formatNG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X00.25 0		Purchased	No			100	f	16.2920	0.1666	4.208842			



6061-T6 Bar .750 x .250



F.R. 11/07/26

Location

Loc Qty

Loc Code

MAT003

16.292

114968

16.292

4.00

D1049P

x24

CZ11/08/25

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

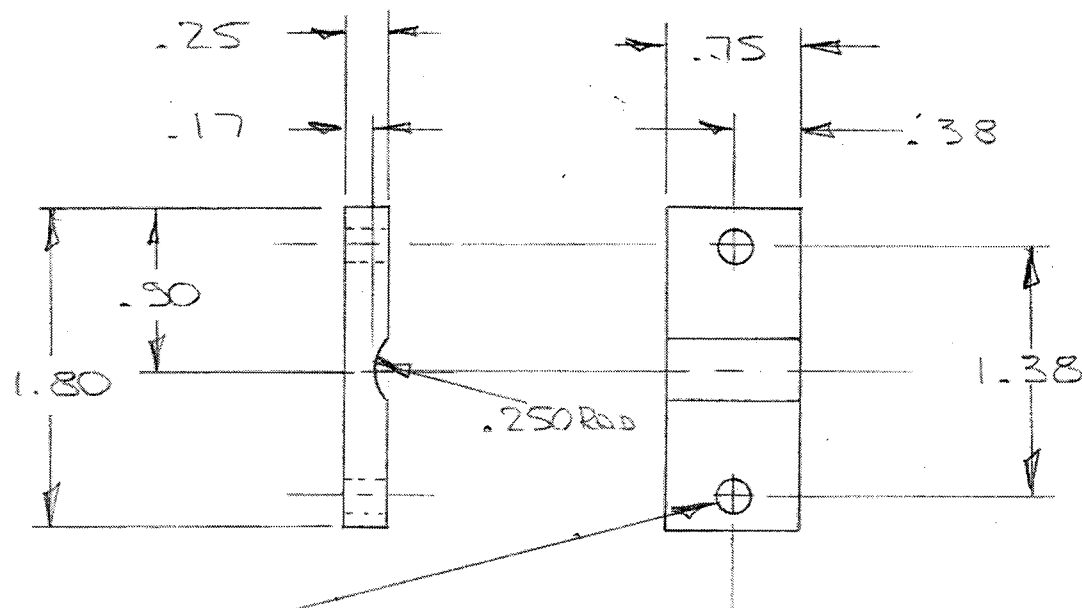
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED  
97/07/02 BW



.203 DIA.  
TYP

#71871

MATERIAL : SOSZ-H32

FINISH : POWDER COAT



REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
DRAWN			BASIC CODE	DIA. DASH NO. W-HEAD REAR SIDE P-HEAD FEAR SIDE	CONTRACT NO.		<b>DART</b> DART AERO ACCESSORIES INC. VANCOUVER CANADA		
APPROVED			D-DRAWN D-DTH-NO OF SHEETS C-COUNTERSINK	LENGTH DASH NO. W-SPOTWELD	DATE				
DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES		DESIGN	TITLE			
	GENERAL	LIMITS	BPMMS20470AD BB-MAS 20476AD		STRESS	SADDLE			
	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125-1 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - 8 - 3742 5. HOLES PER AND 10387	1. TOLERANCES — .XX .030 .XXX .010 2. ANGLES 1/2 1/2 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005			CHECKED	CODE			
	REPORT ALL DISCREPANCIES — DO NOT SCALE				CLIENT	D1049			
					SCALE	1:1	SHT	OF	REV.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DAN'S PRECISION TOOLS INC.**

2560 Devine Road, Vars, ON K0A-3H0  
Tel: (613) 835-3097 Fax: (613) 835-3760  
support@dans-precision-tools.com

**PACKING SLIP**

Ship To: DART AEROSPACE LTD.  
1270 Aberdeen Street  
Hawkesbury ON K6A-1K7

Number: 10681

Date: August 25, 2011

Customer's Order: PO14572

Item#	Line#	Qty	Part #	Description	Status
1	11	24	D1049revNil ✓	Saddle	Complete

CL11108125

Number of Packages: ☐ Boxes \_\_\_\_\_  
☐ Bags \_\_\_\_\_  
☐ Bundles \_\_\_\_\_

Received by: \_\_\_\_\_ Date: \_\_\_\_\_

**DAN'S PRECISION TOOLS INC.**

2560 Devine Road, Vars, ON K0A3H0  
Tel: (613) 835-3097 Fax: (613) 835-3760  
support@dans-precision-tools.com

**RE: CERTIFICATE OF COMPLIANCE**

**To:** DART AEROSPACE LTD.  
1270 Aberdeen Street  
Hawkesbury ON K6A-1K7  
  
Tel: (613) 632-5200  
Fax: (613) 632-5246

- We Certify that the part listed below meets the intent of the Purchase Order, and all applicable drawings and specifications.

**Date** : 25-Aug-11

**Purchase Order** : PO14572

**Packing Slip** : 10681

**Part Number** : D1049revNil

**Quantity** : 24

*8 Aug/26*

**Per:** \_\_\_\_\_

**For Dan's Precision Tools Inc.**

**DAN'S PRECISION TOOLS INC.**

Customer: DART AEROSPACE

P.O.: PO14572

W/O: \_\_\_\_\_

Part #: D1049 rev Nil

Saddle

Qty: 24

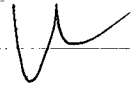
1 of 1

**Work Order ID 76150****\*76150\***

Page 1

November-08-11 9:53:09 AM

Item ID: D1049 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Saddle  
Start Date: 11/08/11 Start Qty: 6.00 **\*6\*** Cust Item ID:  
Required Date: 11/08/11 Req'd Qty: 6.00 **\*6\*** Customer:  
Reference: to correct costing

Approvals: Process Plan:  Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

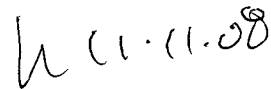
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D1049	Rev A								

180	QC21- Final Inspection - Work Order Release	0.00
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**\*180\***

QC	Memo	0.00
Quality Control	to pull purchased part to correct costing	



# Picklist Print

November-08-11 9:53:08 AM

Page 1

Work Order ID: 76150

Parent Item: D1049

Parent Item Name: Saddle

Start Date: 11/08/11

Required Date: 11/08/11

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevC02.04.10Re-formatNG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D1049 Saddle		Manufactured	No				Each	6.0000		6			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST002		6							
				71871		6							
D1049P SADDLE		Purchased	No				Each	0.0000		24			

Item ID	Trans Type	Trans Date	Inv Change Amt
D1049	Startup LOC Tracking	12/05/09 18:07	0
D1049	Account Value Change	12/05/09 18:07	0
D1049	Account Value Change	12/05/09 18:07	0
D1049	Inv Adjustment	12/05/09 18:07	313.3704
D1049	Issue	12/15/09 16:31	-119.3792
D1049	Loc Maint	1/14/10 12:37	0
D1049	Loc Maint	1/14/10 12:38	0
D1049	Loc Transfer	1/14/10 12:48	193.9912
D1049	Loc Transfer	1/14/10 12:48	-193.9912
D1049	Issue	1/18/10 10:13	-119.3792
D1049	Account Value Change	1/18/10 16:02	0
D1049	Account Value Change	1/18/10 16:02	0
D1049	WIP Receipt	1/18/10 16:02	119.174
D1049	Lot Maintenance	1/19/10 14:49	0
D1049	Account Value Change	3/01/10 11:38	0
D1049	Account Value Change	3/01/10 11:38	0
D1049	WIP Receipt	3/01/10 11:38	114.9324
D1049	Lot Maintenance	3/03/10 13:51	0
D1049	Loc Transfer	3/08/10 13:28	191.554
D1049	Loc Transfer	3/08/10 13:28	-191.554
D1049	Loc Transfer	3/08/10 13:29	114.9324
D1049	Loc Transfer	3/08/10 13:29	-114.9324
D1049	Issue	3/10/10 10:55	-95.777
D1049	Issue	4/19/10 8:59	-76.6216
D1049	Issue	4/20/10 10:18	-76.6216
D1049	Account Value Change	4/27/10 12:34	2.7797
D1049	Issue	6/21/10 7:51	-78.6432
D1049	Account Value Change	6/23/10 7:54	0
D1049	Account Value Change	6/23/10 7:54	0
D1049	WIP Receipt	6/23/10 7:54	670.1
D1049	Lot Maintenance	6/23/10 8:23	0
D1049	Issue	7/06/10 8:37	-134.02
D1049	Account Value Change	7/28/10 15:26	0



D1049	Account Value Change	7/28/10 15:26	0
D1049	WIP Receipt	7/28/10 15:26	403.676
D1049	Lot Maintenance	7/29/10 9:59	0
D1049	Issue	8/03/10 10:11	-201.838
D1049	Account Value Change	11/26/10 14:47	-0.6554
D1049	Issue	12/15/10 14:14	-161.2896
D1049	Issue	1/20/11 8:37	-161.2896
D1049	Issue	2/03/11 8:45	-40.3224
D1049	Issue	2/28/11 13:00	-40.3224
D1049	Issue	3/02/11 9:57	-80.6448
D1049	Loc Transfer	3/10/11 12:48	100.806
D1049	Loc Transfer	3/10/11 12:48	-100.806
D1049	Issue	4/04/11 8:23	-80.6448
D1049	Account Value Change	4/11/11 11:18	0
D1049	Account Value Change	4/11/11 11:18	0
D1049	WIP Receipt	4/11/11 11:18	102.3078
D1049	Lot Maintenance	4/11/11 13:04	0
D1049	Issue	5/03/11 16:57	-19.4872
D1049	Issue	5/13/11 7:01	-19.4872
D1049	Issue	6/06/11 8:20	-19.4872
D1049	Issue	6/29/11 7:17	-29.2308
D1049	Issue	7/25/11 12:38	-19.4872
D1049	Account Value Change	8/29/11 11:18	0
D1049	Account Value Change	8/29/11 11:18	0
D1049	WIP Receipt	8/29/11 11:18	88.5912
D1049	Lot Maintenance	8/29/11 13:17	0
D1049	Issue	8/29/11 13:31	-14.7652
D1049	Issue	8/29/11 13:35	-22.1478
D1049	Issue	9/21/11 11:21	-29.5304
D1049	Rework	11/08/11 9:48	-22.1478
D1049	Account Value Change	11/08/11 9:49	0
D1049	Account Value Change	11/08/11 9:49	0
D1049	WIP Receipt	11/08/11 9:49	130.1478

## Reference

Old value 0

New value 14.9224

Item Revision Consolidation Automation; Acct#: 60100-50; Emp ID: INS007

Work Order ID: 54020, Reason: , Employee ID: DCUSER

14/01/2010 12:37:43 PM

14/01/2010 12:38:30 PM

Work Order ID: 54975, Reason: , Employee ID: DCUSER

Old value 14.9224

New value 5.9587

Work Order ID: 55028, Employee ID: FAUT01

1/19/10 14:49

Old value 5.9587

New value 9.5777

Work Order ID: 56284, Employee ID: LAVO01

3/03/10 13:51

Work Order ID: 55488, Reason: , Employee ID: DCUSER

Work Order ID: 57482, Reason: , Employee ID: DCUSER

Work Order ID: 56244, Reason: , Employee ID: DCUSER

9.58 -> 9.83

Work Order ID: 59872, Reason: , Employee ID: DCUSER

Old value 9.8304

New value 33.5050

Work Order ID: 58396, Employee ID: LACE01

6/23/10 8:23

Work Order ID: 58870, Reason: , Employee ID: DCUSER

Old value 33.5050

New value 20.1838

Work Order ID: 60501, Employee ID: LACE01

7/29/10 9:59

Work Order ID: 60392, Reason: , Employee ID: DCUSER  
20.18 -> 20.16

Work Order ID: 64680, Reason: , Employee ID: QUIR01

Work Order ID: 65571, Reason: , Employee ID: DCUSER

Work Order ID: 65732, Reason: , Employee ID: QUIR01

Work Order ID: 66789, Reason: , Employee ID: DCUSER

Work Order ID: 66648, Reason: , Employee ID: QUIR01

Work Order ID: 67330, Reason: , Employee ID: DCUSER

Old value 20.1612

New value 4.8718

Work Order ID: 67680, Employee ID: FAUT01

4/11/11 13:04

Work Order ID: 68655, Reason: , Employee ID: QUIR01

Work Order ID: 69413, Reason: , Employee ID: DCUSER

Work Order ID: 70167, Reason: , Employee ID: DCUSER

Work Order ID: 71348, Reason: , Employee ID: DCUSER

Work Order ID: 71217, Reason: , Employee ID: QUIR01

Old value 4.8718

New value 3.6913

Work Order ID: 71871, Employee ID: FAUT01

8/29/11 13:16

Work Order ID: 72755, Reason: , Employee ID: FAUT01

Work Order ID: 71217, Reason: , Employee ID: FAUT01

Work Order ID: 73954, Reason: , Employee ID: DESJ02

Rework ID: 76150, Reason: , Employee ID: LACE01

Old value 3.6913

New value 21.6913

Work Order ID: 76150, Employee ID: LACE01